

Work Order ID 56321

February 17, 2010 2:38:13 PM



Page 1

Item ID: D3784-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Support Assembly, LH

Start Date: 2/17/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

14

Date: *10-2-17*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3784	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3784□****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented up****□****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented AFT****								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 10/05/14

EP 10/03/29 (4)

EP 10/05/14

EP 10/03/29 (4)

2/16/14

(4)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56321

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Page 2

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Customer:



Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>g47</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10-5-17 (4x) SP

10/05/17 JA

PS 10-5-17 (14)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:38:17 PM

Page 1

Work Order ID: 56321

Parent Item: D3784-043

Parent Item Name: Seat Support Assembly, LH

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Date: 2/17/10

Required Date: 2/24/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R20		Purchased	No			110	Each	45.0000	16.0000			
Screw												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45

113524

45

110

Each

3,445.000

16.0000

AN960JD10L

Purchased

No

Washer QSI017

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3445

101291

16

105793

49

110985

3380

110

Each

4.0000

8.0000

D3763-041

Manufactured

No

End Fitting Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST251

4

54314

1

55380

3

B57929 (6x)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

February 17, 2010 2:38:17 PM

Work Order ID: 56321

Parent Item: D3784-043

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Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3763-043		Manufactured	No			110	Each	4.0000	4.0000			
End Fitting Assembly, LH												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

55107

4

D3770-1

Manufactured No

110

Each

10.0000

4.0000

Tube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

10

54316

10

D3770-3

Manufactured No

110

Each

17.0000

4.0000

Tube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

17

42963

1

54318

16

Ep 5/10/05/14

4
Ep 5/10/05/14

B56569 (22)

2
Ep 5/10/05/14

4

February 17, 2010 2:38:17 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Parent Item Name: Seat Support Assembly, LH

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			110	Each	2,661.000	16.0000			



Handwritten signature and date: 2/20/10

Nut

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2655

110844

35

111274

27

111668

52

112314

285

112385

498

113523

58

113537

700

113644

1000

16

Main Warehouse

ST139

6

111668

6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

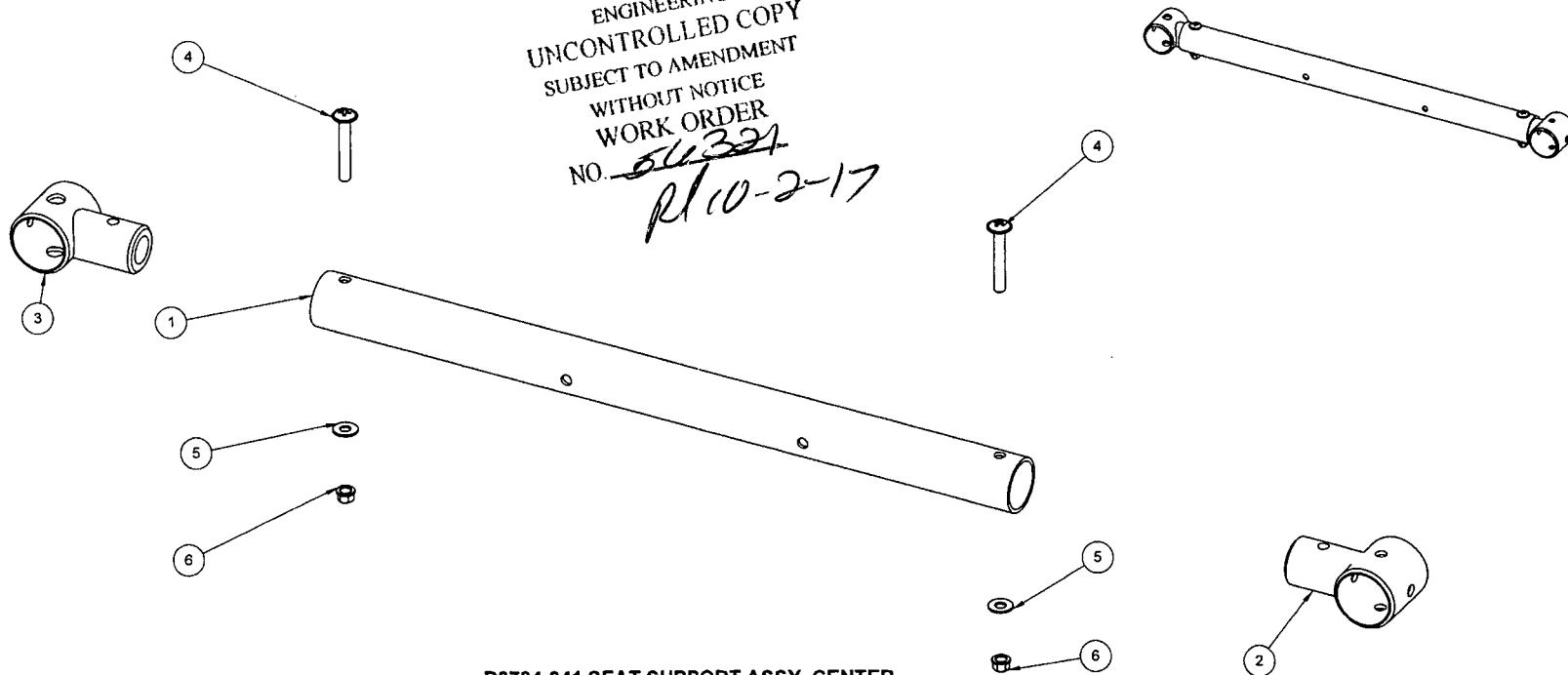
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54321
R10-2-17



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

△
B
△
B
△
B
△
B

NOTES:

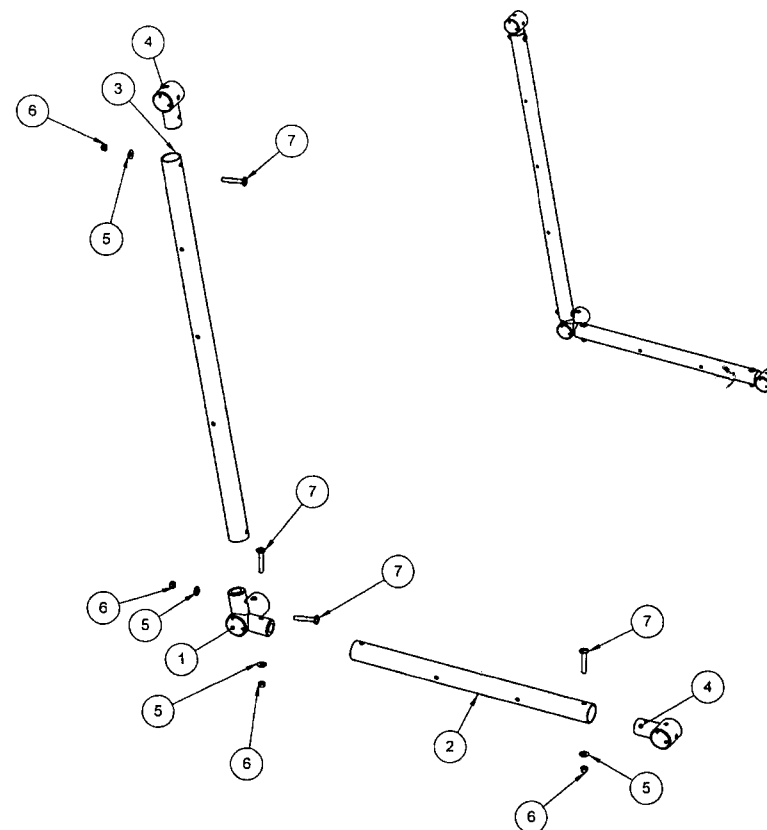
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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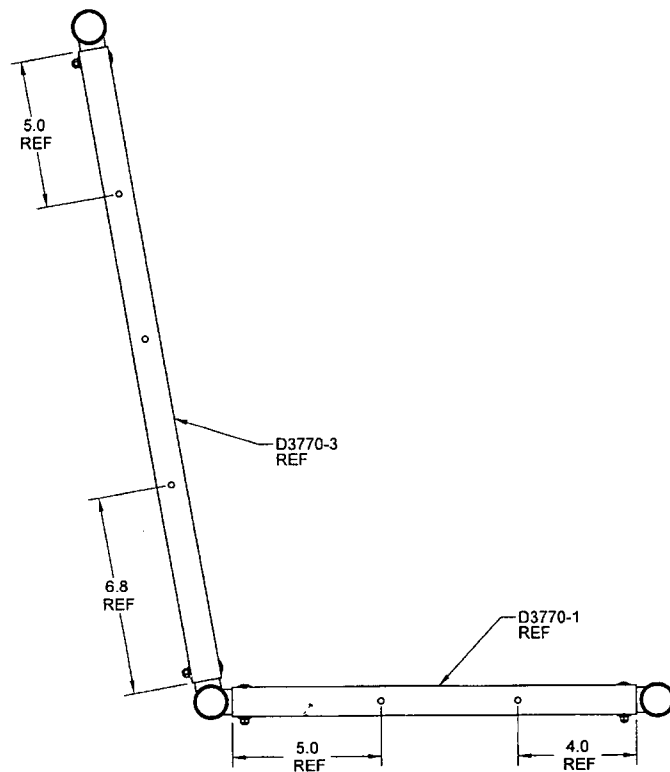
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	M2042L3	NUT	4
7	AN525-10R20	SCREW	4

D3784-043 SEAT SUPPORT ASSY, LH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs



DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.		D3784	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SEAT SUPPORT ASSEMBLY	NTS
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D3784-043 SEAT SUPPORT ASSY, LH

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
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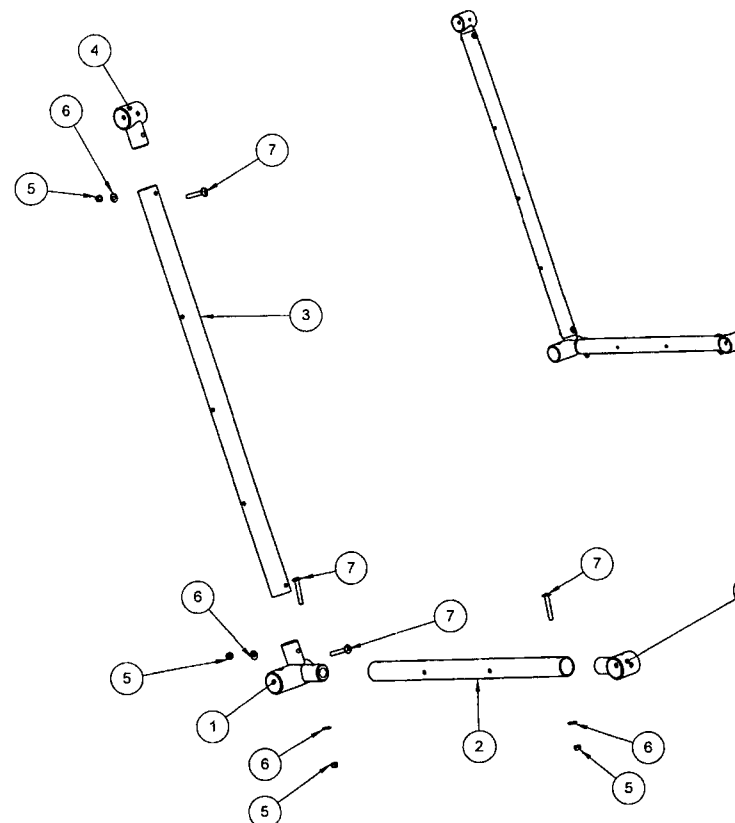
wlo 36321

08.07.10 J.H.

8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-044 SEAT SUPPORT ASSY, RH

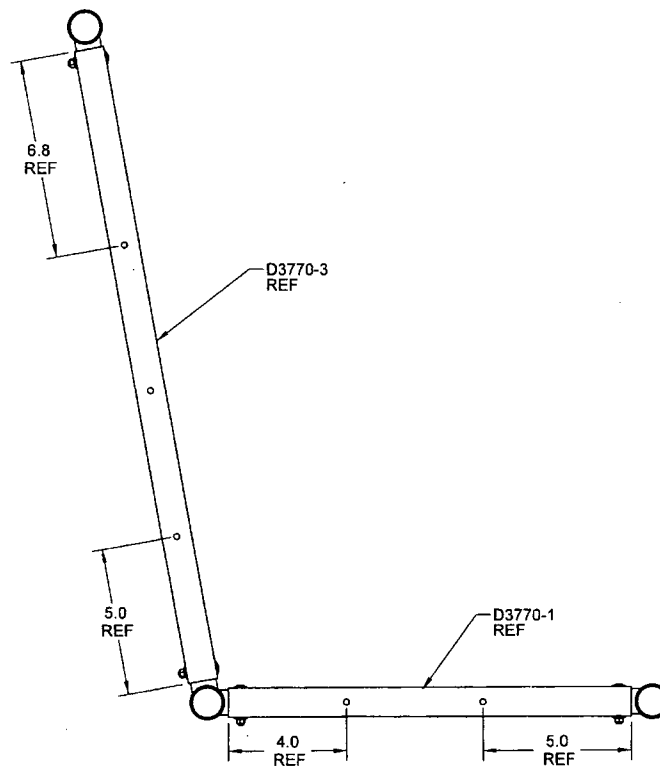
wlo 56321

RELEASED

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3784-044 SEAT SUPPORT ASSY, RH

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	MP	D3784	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SEAT SUPPORT ASSEMBLY	NTS
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WLO 54321

108.07.10.10